

20-8624

20-8623



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

645.7110

Job Sheet 213821

Accounting Job SE CAD 139 Valve



Part No: 645.7110

Job Qty: 1 pcs

Part Name: Lock Nut Swivel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/20

Job Tracking No:

Due Date: 10/16/20

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: 645.7100 REV.B IPP RE:A 20.10.07 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	1 pcs	10/19/20		1.00	1.00	Doosan - 1		
							NLX 2500SY - 1		
							SL-154 - 1		
							SL-2500Y - 1		JK 20-10-13
110	QC 2	1 pcs	10/19/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		JK
							QC 2 - 32		
							QC 2 - 33		
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							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S306168



Part: 645.7110

Job No: 213821

Serial No/Batch: S306168

Revision: REV.B

Inspector:

Exp Date:

Instructions:

DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 10/13/20

Plex 10/7/20 12:49 PM Dart.lajeunesse.marie

P.T.O.

P.T.O.

10/7/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	1 pcs	10/19/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
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					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
160	Packaging 3-1 - Stock - B4B	1 pcs	10/19/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
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					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B

7/20/10/15

DAS
82
9-89

OCT 16 2020

10/7/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	1 pcs	10/19/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	

Part Op **100** - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio F FOLIO REV: _____
 Descriptions: DWG REV: _____ 2-Deburr FD400
110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
160 - Identify as per dwg & Stock *****CRITICAL PART - EXTREME CARE MUST BE TAKEN***** *****MUST ENSURE THE COMPONENTS ARE NEVER DAMAGE*****
170 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	.0630 ft (.063 ea)	100-SL-154 - 1	S302988

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M303R0.750	0	38	0

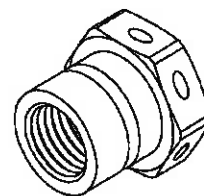
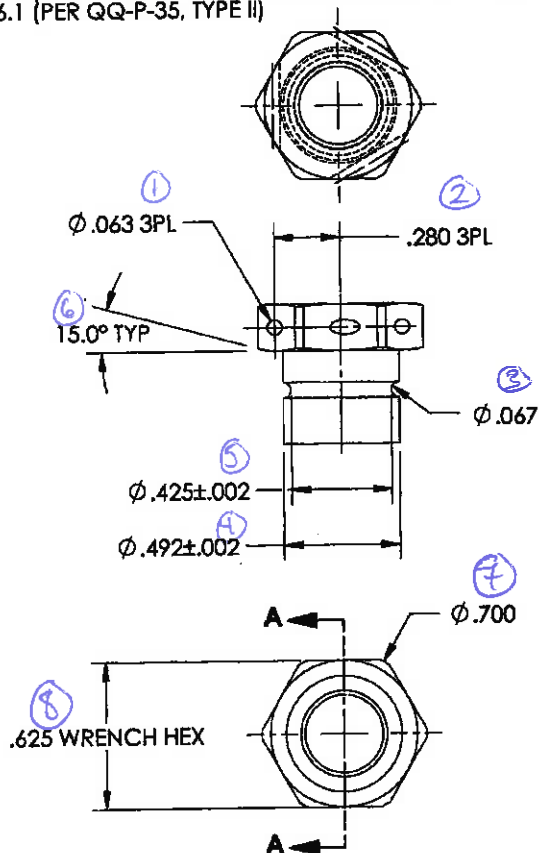
Part Specifications	
Specifications could not be found.	

Plex 10/7/20 12:49 PM Dart.lajeunesse.marie

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NOTES: UNLESS OTHERWISE SPECIFIED

1. DELETED.
2. MATERIAL: STAINLESS STEEL 303 1AW AMS-5640. (13)
3. IDENTIFY 1AW MPP-120.
4. FINISH: ELECTROPOLISH 1AW DART AEROSPACE SPEC MPP-172, SECTION 7.1 (PER ASTM B912-02), PASSIVATE 1AW MPP-172, SECTION 6.1 (PER QQ-P-35, TYPE II) (14)



645.7110 SHOWN

SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 213821 MLW
2010-07

REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	01/25/2001	P. BRAYO
A	INCORPORATED BOM 04/01 & 0005	07/15/2014	P. BRAYO
B	INCORPORATED BOM 0005	11/17/2015	P. BRAYO

QTY	FIGURE	PART #	DESCRIPTION	MATL	SPEC.
2	645.7111	LOCK NUT SWIVEL TYPE			
1	645.7110	LOCK NUT SWIVEL TYPE			

QTY	FIGURE	PART #	DESCRIPTION	MATL	SPEC.
2	645.7111	LOCK NUT SWIVEL TYPE			
1	645.7110	LOCK NUT SWIVEL TYPE			

ORIGINAL DATE	01-25-01
DRAWN BY	CHICOR
CHECKED BY	P. BRAYO
DESIGNED BY	P. BRAYO
APPROVED BY	P. BRAYO
DATE	01-25-01
SCALE	NONE

UNLESS OTHERWISE SPECIFIED	
OVERSIZES ARE IN INCHES	
OVERSIZES ARE IN MILLIMETERS	
2 PLACE DECIMALS	
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Ketan Tailor

From: Jacob Becker
Sent: October-07-20 4:57 PM
To: Ketan Tailor
Cc: Steven Drouin
Subject: RE: Deviations for Valve Pull Force Test Tool

Understood.

Per our conversation these deviations are acceptable.

Regards,

JACOB BECKER
Lead Sustaining Engineer

DART AEROSPACE
T 1 760 509-1639
M 1 760 691-9108

From: Ketan Tailor <ktailor@dartaero.com>
Sent: Wednesday, October 07, 2020 1:48 PM
To: Jacob Becker <jbecker@dartaero.com>
Cc: Steven Drouin <sdrouin@dartaero.com>
Subject: RE: Deviations for Valve Pull Force Test Tool

Hey Jacob,

We measure the CBL-1240 Cable we have in stock and we will not deviate the 645.7810 Cable Rod.

The diameter of the uncoated Cable was 0.063".

Thanks,
Ketan

From: Ketan Tailor
Sent: October-07-20 4:35 PM
To: Jacob Becker <jbecker@dartaero.com>
Subject: Deviations for Valve Pull Force Test Tool

Hey Jacob,

We would like to make changes to the following P/Ns in order to decrease the lead time for the 607.3301 Valve Pull Force Test Tool

607.3301 Valve Pull Force Test Tool

- Replace 601.1581 Cable with CBL-1240
- Replace 601.1054 Crimp Sleeve with CBL-460
- Replace 601.2330 Cotter Pin with MS24665-103

650.7910 Shroud

- Omit outsourcing for Passivation

645.7910 Cable Housing

- Omit outsourcing for Passivation

~~645.7810 Cable Rod~~

- ~~Dimension was 0.072+/-0.005 is 0.063 +0.004/-0.001~~

645.7110 Lock Nut Swivel Type

- Omit outsourcing for Electropolish and Passivation.

Please confirm if these changes are acceptable.

Thanks,
Ketan

39697-5761

10057281



An ISO 9001 : 2015 Certified Company

Regd. Office & Works: Plot No.: 235, Sarkhej Bavia, N.H. No. 8-A, Village Sari, Taluka Sanand,
Dist.: Ahmedabad-382220, Gujarat, India
T.: 02717-61080 (100 lines), I F : 02717-610824
E: sales@gopalgroup.com | W: www.gopalgroup.com

Inspection Certificate 3.1 According To EN 10204 : 2005

Test Certificate No. : 109277
Date of Issue : 14-October-2019
P. O. No. : MN6575-BN6576 & MN6535-BN6636-MN6648
Invoice : LSL/19-20/4253
CIR NO : U27100GJ1999PLC056413

Product	Grade	Supply Condition	Colour Code	Process Route	Stamp of Engineer	Length (Feet)	Tolerance	Weight Lbs
STAINLESS STEEL BRIGHT ROUND BARS " LAXCON BRAND"	AISI 303	Drawn & Polished	YELLOW	EIF-AOD-LR-Fully Killed	SRI	12'-14'	h9	1470

Chemical Composition (Weight %)

	C	Mn	Si	S	P	Cr	Ni	N		No of Bndl	Size (Inch)	Pcs
Min.	-	-	-	0.150	-	17.00	8.00	-				
Max.	0.15	2.00	1.00	-	0.045	19.00	10.00	-				
Heat No.	19L1239	0.039	1.79	0.35	0.254	0.039	17.23	8.05	0.0560	1	3/4"	70

Test Method - ASTM A370 / Test Condition - Solution Annealed

Specified Value	Proof Strength N/mm2	Tensile Strength N/mm2/ (Rm)	Elongation after Fracture A %	Reduction of Area %	Hardness HBW	Test Method :- ASTM E-23 Charpy (V) Impact Test (2mm) at (Joules)			
-	0.2% (Rp 0.2)	-	-	-	Min Max	I	ii	iii	Avg.
SPEC	-	-	-	-	-	-	-	-	-
19L1239/3/4"	346	659	56.02	60.15	180 185	-	-	-	-

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Remarks:

- The material is free from Radioactive and Mercury contaminations.
- Lead has not added during manufacturing.
- Steel is fully killed by Aluminum for fine grain structure.
- Material confirms the requirements as per ASTM A582: 2017.

We here by certify that above material described herein has been manufactured and tested with satisfactory results in accordance with the Specification & requirements

For Laxcon Steels Ltd.

Authorized Signatory (Q.C.)

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M303R0.750
 DATE: SEP 25 2020

PO / BATCH NO.: POHB047147
 S302988

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 56 FT
 QUANTITY INSPECTED: 56 FT
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.750
 THICKNESS RECEIVED: 0.750
 SHEET SIZE ORDERED:
 SHEET SIZE RECEIVED:

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒	
CORRECT FINISH	Y ☒	
CORROSION	Y ☒	
CORRECT GRAIN DIRECTION	Y ☒	
CORRECT MATERIAL PER M-DRAWING	Y ☒	ASTM A572
CORRECT THICKNESS	Y ☒	
PHOTO REQUIRED	Y ☒	
CORRECT REF # TO LINK CERT	Y ☒	H/E 196-2239
CORRECT MATERIAL IDENTIFICATION	Y ☒	
CORRECT M# ON THE MATERIAL	Y ☒	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION INSPECTED BY: <u> </u> DATE: <u>SEP 25 2020</u>	ENGINEERING SIGNOFF (if required) SIGNED OFF BY: <u> </u> DATE: <u> </u>
--	---

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

Ketan Tailor

From: Jacob Becker
Sent: October-16-20 1:45 PM
To: Ketan Tailor
Subject: RE: 645.7110 Material Deviation

Hi Ketan,

This alternate spec is acceptable.

Regards,

JACOB BECKER
Lead Sustaining Engineer

DART AEROSPACE
T 1 760 509-1639
M 1 760 691-9108

From: Ketan Tailor <ktailor@dartaero.com>
Sent: Friday, October 16, 2020 10:42 AM
To: Jacob Becker <jbecker@dartaero.com>
Subject: 645.7110 Material Deviation

Hey Jacob,

We need another deviation, this time for 645.7110.

The drawing specifies 303 Stainless Steel per AMS-5640 our M-Drawing specifies ASTM A582, which is what is on the material certs.

Please confirm if this is acceptable.

Thanks,
Ketan

Entered: JE Date: OCT 27 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8623

Route update only ☐

Job: <u>213821</u> Part No. <u>645.7110</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier Quality ☐																															
Date : <u>20-10-15</u>		Sequence #: <u>100</u>		QTY Affected : <u>1</u>		DMRB (QSI042) <u>51</u> <u>9-89</u> <u>20/10/16</u>																													
Description Work Order Deviation MATERIAL SHOULD BE STAINLESS STEEL 303 PER AMS-5640. THE MATERIAL USED IS NOT TO AMS-5640 PER MILL TEST PROVIDED (POHB047147, S302988).				Disposition <u>Acceptable per attached e-mail</u>		Completed By DAS <u>82</u> <u>9-89</u> <u>OCT 16 2020</u>																													
						Lead hand / Supervisor DAS <u>9</u> <u>9-89</u> <u>20-10-16</u>																													
						QC / QA Coordinator DAS <u>9</u> <u>9-89</u> <u>20-10-16</u>																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up																																	
		Other/Details:																																	

Entered: 26 Date: OCT 27 2020



NCR No.

Route update only

Job: <u>213821</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date : <u>20.10.07</u>	Sequence #: <u>100</u>		QTY Affected : <u>1</u>			MRB (QSI042) DAS 51 9-89 <u>SMS 20/10/07</u>			
Description Work Order Deviation <u>Omit Outsourcing for Electropolish and Passivation</u>				Disposition <u>this change was made to reduce lead time</u>				Completed By <u>[Signature] 20/10/15</u>	
								Lead hand / Supervisor <u>PD 20-10-15.</u>	
								QC / QA Coordinator <u>PD 20-10-15</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒		FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☒ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☒ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐							
		Other/Details:							